



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.0112

Job Sheet 213425



Part No: 647.0112

Job Qty: ~~400~~ pcs

DAS
21
9-89

Part Name: Strut Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/25/20

Job Tracking No:

Due Date: 3/5/21 Dec

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.0100 REV.B SHEET 3 IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS IPP REV:B 18.02.08 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	100 pcs		3/4/21	0.17	3.33	Waterjet - Flow		on 20/12/10
110	QC 2	100 pcs		3/4/21	0.00	0.00	QC 2 - 1		on 20/12/10
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
QC 2 - 8									
QC 2 - 66									
QC 2 - 64									

Plex 9/25/20 12:47 PM Dart.lajeunesse.marie

120	QC 8	100 pcs	3/4/21	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
130	Small Fab - Brake NC - B4B	100 pcs	3/4/21	0.25 5.00	QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	Small Fab - Brake NC - B4B	100 pcs	3/4/21	0.25 5.00	QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
130	Small Fab - Brake NC - B4B	100 pcs	3/4/21	0.25 5.00	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
140	QC 5	100 pcs	3/4/21	0.00 0.00		DEC 11 2020
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	

DAS
40
-89

DEC 11 2020

DEC 11 2020

150	Spray Paint - 2 - B4B	100 pcs	3/5/21	0.00 2.34	QC 5 - 40	
					QC 5 - 61	DAS
					QC 5 - 81	81
					QC 5 - 82	9-89
					Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	DAS
					Spray Paint - 4 - B4B	87 DEC 11 2020
160	QC 14	100 pcs	3/5/21	0.00 0.00	QC 14 - 15	o q
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	DAS
					QC 14 - 19	81
					QC 14 - 43	9-89
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
					QC 14 - 82	
					QC 14 - 87	
					QC 14 - 47	
						DEC 14 2020
170	Packaging 3-1 - Stock - B4B	100 pcs	3/5/21	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	DEC 15 2020
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	

Plex 9/25/20 12:47 PM Dart.lajeunesse.marie

180 QC 21 - SA	100 pcs <i>102 pcs mld.</i>	3/5/21	0.00 0.00	Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
				QC 21 - SA - 21	DA
				QC 21 - SA - 70	2
				QC 21 - SA - 9	9-89
				QC 21 - SA - 77	
				QC 21 - SA - 28	

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Form as per dwg) USE DT9834 FOR FORMING
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Spray Paint / NDT Room) PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N PRIME AS PER DWG NOTE 6
 BATCH: 5265778
 160 - (QC14- Inspect Spray Paint)
 170 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 180 - (QC21- Final Inspection - Work Order Release)

DEC 15 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	3.2500 sf (.0325 ea)	100-Waterjet - Flow - 1	<u>52434612</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S14GA	3	81	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Bracket	0.177inches + 0.005 - 0.001	0.182 0.176	<u>Ø.176</u>	
2	Strut Bracket	0.191inches + 0.005 - 0.001	0.196 0.190	<u>Ø.190</u>	
3	Strut Bracket	0.300inches ± 0.030	0.330 0.270	<u>.300</u>	
4	Strut Bracket	0.900inches ± 0.030	0.930 0.870	<u>.901</u>	
5	Strut Bracket	0.350inches ± 0.010	0.360 0.340	<u>.352</u>	
6	Strut Bracket	1.50inches ± 0.03	1.53 1.47	<u>1.509</u>	
7	Strut Bracket	1.006inches ± 0.030	1.036 0.976	<u>1.006</u>	
8	Strut Bracket	0.080inches ± 0.010	0.090 0.070	<u>.074</u>	

Plex 9/25/20 12:47 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

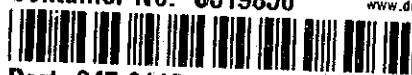
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART
AEROSPACE

Container No: S319850



Part: 647.0112

Job No: 213425

Serial No/Batch: S319850

Revision: 8

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/10/20